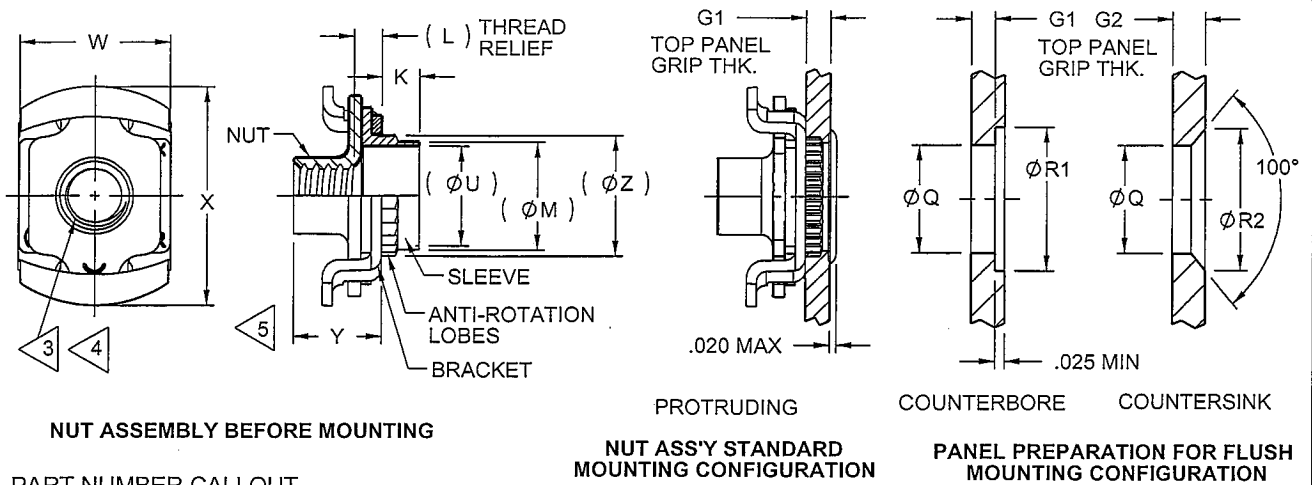


REV
F**S-2971**

DRAWING NO.

**NUT ASSEMBLY BEFORE MOUNTING****PROTRUDING****COUNTERBORE****COUNTERSINK****NUT ASS'Y STANDARD MOUNTING CONFIGURATION****PANEL PREPARATION FOR FLUSH MOUNTING CONFIGURATION****PART NUMBER CALLOUT**

RFF 6010 () - () - ()

THREAD SIZE CODE	(L)	(Ø M)	Ø Q		Ø R1 +.020 -.000	Ø R2 ±.005	(Ø U)	W	X	Y ±.025	(Ø Z)
			SOFT	HARD							
4, 4F, 6, 6F, M3, M3.5	.062	.217	.234	.234	.312	.307	.192	.295	.420	.189	.243
8, 8F, 10, 10C, 10F	.068	.270	.290	.296	.375	.370	.245	.390	.572	.245	.313
12, 12C, 12F	.089	.335	.335	.363	.515	.437	.310	.450	.650	.300	.379

GRIP CODE	G1	G2	K	GRIP CODE	G1	G2	K
AA	N/A	.055-.073	.073	M	.375-.405	.414-.444	.440
A	.031-.062	.074-.106	.099	N	.406-.436	.445-.475	.471
B	.063-.094	.107-.133	.130	P	.437-.467	.476-.506	.502
C	.095-.125	.134-.165	.161	R	.468-.498	.507-.537	.533
D	.126-.156	.166-.196	.192	S	.499-.529	.538-.568	.564
E	.157-.187	.197-.227	.223	T	.530-.560	.569-.599	.595
F	.188-.218	.228-.258	.254	V	.561-.591	.600-.630	.626
G	.219-.250	.259-.289	.285	W	.592-.622	.631-.661	.657
H	.251-.281	.290-.320	.316	X	.623-.653	.662-.692	.688
J	.282-.312	.321-.351	.347	Y	.654-.684	.693-.723	.719
K	.313-.343	.352-.382	.378	Z	.685-.715	.724-.754	.750
L	.344-.374	.383-.413	.409				

MODEL

SERIES

CODE	NUT TYPE
L	LOCKING
NL	NON-LOCKING

THREAD SIZE CODE	THREAD SIZE PER SAE-AS-8879	LEAD	THREAD SIZE CODE	THREAD SIZE PER SAE-AS-8879	LEAD	THREAD SIZE CODE	THREAD SIZE PER ASME B1.21M	LEAD
2	.086-56 UNJC-3B	SINGLE	4F	.112-40 UNJC-3B	DOUBLE	M3	MJ3 x 0.5-4H6H	METRIC
4	.112-40 UNJC-3B		6F	.138-32 UNJC-3B		M3.5	MJ3.5 x 0.6-4H6H	
6	.138-32 UNJC-3B		8F	.164-32 UNJC-3B		M4	MJ4 x 0.7-4H6H	
8	.164-32 UNJC-3B		10F	.190-32 UNJF-3B	QUAD	M5	MJ5 x 0.8-4H6H	
10	.190-32 UNJF-3B		12F	.250-28 UNJF-3B		M6	MJ6 x 1.0-4H6H	
12	.250-28 UNJF-3B							
10C	.190-24 UNJC-3B	SINGLE (COARSE)						
12C	.250-20 UNJC-3B							

F	DCN 6531	05-14-08
REV	DESCRIPTION/EC NO.	DATE

UNLESS OTHERWISE SPECIFIED
ALL DIMENSIONS IN INCHES

TOLERANCE UNLESS OTHERWISE

NOTED:

.X = ±.05 ANGLES ±0.5°
 .XX = ±.02
 .XXX = ±.015

**Alcoa Fastening Systems**

AEROSPACE FASTENER DIVISION
 3724 EAST COLUMBIA STREET
 TUCSON, ARIZONA 85714
 PHONE 520 519-7400
 FAX 520 519-7427
 www.alcofasteners.com

TITLE
**NUT PLATE, 450° F,
 REPAIR, ALL SIZES,
 RIVETLESS, FLOATING**

DATE 02/01/2007	PART NUMBER RFF6010()
DRAWN JLS	DRAWING NO. S-2971
CHECK <i>[Signature]</i>	CAGE CODE OHDW7
APPROVE	REV F
SCALE: 2:1	SHEET 1 OF 2

ORIGINAL
 Red Ink Indicates
 Original Copy

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REV

F

DRAWING NO.

S-2971

MATERIAL:

SLEEVE: 304 CRES PER AMS 5639 OR 304 CRES PER AMS 5514
 NUT: 1050 CARBON STEEL PER AMS 5085, HEAT TREAT TO 160K PSI MIN. U.T.S.
 BRACKET: 1050 CARBON STEEL PER AMS 5085, HEAT TREAT TO HRC 42-47

FINISH CODE:

ALL COMPONENTS: CAD PLATE PER AMS QQ-P-416, TYPE II, CLASS 2
 NUT: DRI-FILM LUBE PER MIL-PRF-46010
 SLEEVE: DYED RED AND/OR MARKED WITH "R" (FOR REPAIR SLEEVE)

NOTES:

- 1 "AA" GRIP RECOMMENDED PANEL PREPARATION:
 SIZES 2, 4, 4F, 6, & 6F C'SINK: "Ø R2" DIMENSION IS .275
 SIZE 8, 8F, 10, 10C, & 10F C'SINK: "Ø Q" DIMENSION IS .276/.281; "Ø R2" DIMENSION IS .343
 SIZE 12, 12C, & 12F: NOT RECOMMENDED FOR LESS THAN .060 PANEL THICKNESS
- 2 SOFT: DIMENSIONS FOR SOFT ALUMINUM ALLOYS AND PLASTICS
 HARD: DIMENSIONS FOR HARD ALUMINUM ALLOYS AND STEEL
- 3 A MINIMUM OF TWO THREADS ARE DEFORMED TO PRODUCE SELF-LOCKING ACTION PER NASM25027 WHEN LOCKING FEATURE IS DESIRED.
- 4 NUT ELEMENT HAS .060 TOTAL RADIAL FLOAT FOR GRIP LENGTHS "AA" THRU "C" AND .046 MINIMUM FOR GRIP LENGTHS GREATER THAN "C".
- 5 FOR NUT ELEMENT REPLACEMENT PART NUMBER, SEE DRAWING S-0877.
- 6 NUT ELEMENT REMOVAL TOOL AVAILABLE, PART NUMBER RB 6527.
- 7 FOR HIGH VOLUME INSTALLATION RATES, ALTERNATIVE POWER TOOLING IS AVAILABLE:
 CONTACT ALCOA FASTENING SYSTEMS SALES DEPT.
- 8 NUT ELEMENT COLOR CODE:
 NONE: LOCKING STANDARD THREADS
 GREEN: NON-LOCKING STANDARD THREADS
 YELLOW: COARSE THREADS
 ORANGE: FAST LEAD THREADS
 SKY BLUE: "MJ" METRIC THREADS
- 9 THREAD SIZE CODE

HAND INSTALLATION TOOL SELECTION TABLE:

COMPLETE HAND TOOL ASSEMBLY (INCLUDES:NOSE PIECE, PULLER & HANDLE)		NOSE PIECE	
		COUNTERBORE	COUNTERSINK
COUNTERBORE	COUNTERSINK	DCBN86130-(9)	DCSN86130-(9)
DCBT8600-(9)	DCST8600-(9)	PULLER: DTP86230-(9)	
HANDLE ASS'Y: TA7533			

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F	DCN 6531	05-14-08
REV	DESCRIPTION/EC NO.	DATE
UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS IN INCHES		
TOLERANCE UNLESS OTHERWISE NOTED:		
.X	= ±.05	ANGLES ±0.5°
.XX	= ±.02	
.XXX	= ±.015	



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TITLE

**NUT PLATE, 450° F,
REPAIR, ALL SIZES,
RIVETLESS, FLOATING**

DATE	02/01/2007	PART NUMBER	RFF6010()
DRAWN	JLS	DRAWING NO.	S-2971
CHECK	<i>SA</i>	CAGE CODE	OHDW7
APPROVE		REV	F
SCALE: 2:1		SHEET 2 OF 2	